

member 14 clamps the tag 2, which is approaching most closely to the sheet 11 (hereunder, which is referred to as "first-step tag 2"). Upon claiming, the clamp head 14a is rotated two or three times by driving the rotary head 14b. As the clamp head 14a is being rotated, the first-step tag 2 is being rotated and the suspending line 3 is being wound on the first-step tag 2. As shown in Fig. 3(b), as a result, there is produced the wound portion 3c in which a middle portion of the suspending line 3 is being wound on the tag 2. As described above, because one end 3a of the suspending line 3 has been fixed to the tag 2 at substantially the central location thereof, the wound portion 3c can satisfactorily and surely be produced in the notch parts 4 of the tag 2.

After the wound portion 3c is produced, the drawing member 14 is moved straightly, in a transverse direction over the sheet 11, whereby the whole of the suspending member 1 is drawn over the sheet 11. That is, the first-step tag 2 is transferred together with the suspending line 3 over the sheet 11. When the first-step tag 2 reached one edge of the longitudinal side of the sheet 11, the suspending line 3 is being placed across the sheet 11.

Thereafter, the first-step tag 2 and a back point of the suspending line 3 are simultaneously fixed to the sheet 11 by ultrasonic welding. The ultrasonic welding is done by interposing the sheet 11, the first-step tag 2 and the back

09974849.101201

point of the suspending line 3 between a ultrasonic vibration hone and a receiving pedestal (both not shown). By the ultrasonic welding, the first-step tag 2 is fixed to the sheet 11 at the fixing points 13. Simultaneously with the ultrasonic welding, the suspending line 3 is cut off by the cutter 16 behind of the back point. As a result, the back point of the suspending line 3 will make the other end 3b fixed to the sheet 1. Thereafter, the sheet 11 is delivered by a given distance in the direction shown by the arrow A.

During these operations on the first-step tag 2, the clamp head 15b of the drawing member 15 is clamping behind the first-step tag 2, another tag 2 (hereunder, which is referred to as "second-step tag 2". When the suspending line 3 fixed to the first-step tag 2 has been cut, the rotary head 15b starts to drive and rotate the second-step tag 2. Thereby, another wound portion 3c of the suspending line 3 is produced in the notch parts 4 of the second-step tag 2. Thereafter, the above-explained operations are done repeatedly. As a result, the packing material 10 (in which the suspending member 1 is attached to the sheet 11) is continuously manufactured.

Fig. 3 illustrates no more than the embodiment. The packing material can be manufactured by other process. For example, after the wound portion 3c has been produced by winding a middle portion of the suspending line 3 on the tag 2, the tag 2 and the suspending line 3 may be supplied to the sheet

11.

Fig. 4 shows another embodiment of the packing material 10. In this embodiment, the suspending line 3 of the suspending member 1 is not placed across the sheet 11 perpendicularly to the longitudinal side of the sheet 11, but is placed shifted forward and backward. Even in such situations, if the wound portion 3c has been produced by winding the suspending line 3 on the tag 2, the suspending line 3 can have a sufficiently long length. The packing material 10 can be manufactured by transferring the drawing members 14, 15 forward or backward along the longitudinal side of the sheet 11.

Figs. 5 and 6 show embodiments of the packages 20 being formed of the packing materials 10, respectively. Each of the packages 20 comprises a bag body 21 and the suspending member 1. In Fig. 5, the bag body 21 has a flat shape and in Fig. 6, the bag body 21 has a tetra shape. However, the bag body 21 should not be limited to have the Figs. 5 or 6 shapes.

The packing material 11 of a liquid-permeable sheet can be formed to the bag body 21 of a given shape. For example, the packing material 11 shown in Figs. 2 and 4 is formed to a continuous cylinder-like body, either end thereof is sealed, an extracting material is enclosed in the cylinder-like body, and finally the other end of the cylinder-like body is sealed.

00974849-101201